

# Work Order ID 71135

Thursday, June 23, 2011 11:07:58 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: 117884

\*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
DRILL HOLES FOR GAS SPRING  
IN D3825-041 AS PER  
DS19473

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.08.16

11.08.16

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

IX Ø M-14/08/16

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

M 118439

1ST COAT:

START TIME: 8:45

OVEN TEMPERATURE: 4:00

FINISH TIME: 9:15

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

IX 8 M-11/08/17

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d M-11/08/17

**Work Order ID 71135**

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Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

*w/o 71133*

0.00

Packaging

*EP 11/08/18 @*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/8/18**11-08-18*

# Picklist Print

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Page 1

Work Order ID: 71135

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1		Manufactured	No			100	Each	16.0000	1	1			
Rib													

Location Loc Qty Loc Code

WA 7  
 69261 7  
 WA006 9  
 67465 9

B71372 → ①

D2221-5		Manufactured	No			100	Each	10.0000	2	2			
Rib													

Location Loc Qty Loc Code

WA006 10  
 67117 2  
 69257 8

B71218 → ②

D2221-7		Manufactured	No			100	Each	5.0000	1	1			
Rib													

Location Loc Qty Loc Code

WA 4  
 70130 4  
 WA006 1  
 67274 1

B71219 → ①

# Picklist Print

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Page 2

Work Order ID: 71135

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

6.0000

2

2



Basket Hinge

Location

Loc Qty

Loc Code

WA005

6

69211

6

100

Each

8.0000

2

2

D2235-1

Manufactured No



Basket Rib

Location

Loc Qty

Loc Code

WA

4

69651

4

WA005

4

66895

4

100

Each

105.0000

2

2

D2581

Manufactured No



Mounting Bracket

Location

Loc Qty

Loc Code

WA

105

68964

4

69258

28

69739

22

70766

51

100

Each

5.0000

2

2

D3442-1

Manufactured No



Shim

Location

Loc Qty

Loc Code

WA005

5

64271

2

65783

3



pl 11.08.16  
B71796 → (2)

pl 11.08.16  
B71940 → (2)

pl 11.08.16

pl 11.08.26  
B71224 → (2)

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Shop Packet Print

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# Picklist Print

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Page 3

Work Order ID: 71135

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No

100 Each

6.0000

2

2



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

6

69984

2

70426

4



PL11.08.16  
B72080 → ②

D3826-041 Manufactured No

100 Each

6.0000

2

2



Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

6

67464

2

70117

4



PL11.08.16  
B71805 → ②

D3827-041 Manufactured No

100 Each

5.0000

1

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

5

69114

5



PL11.08.16  
B72083 → ①

D3832-1 Manufactured No

100 Each

2.0000

1

1



Mesh (Base)

Location

Loc Qty

Loc Code

WA

2

69173

2



PL11.08.16  
B71644 → ①

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# Picklist Print

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Work Order ID: 71135



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

7.0000

2

2



Mesh (Base End Face)



Pl 11.08.16

Location

Loc Qty

Loc Code

WA

7

67459

7

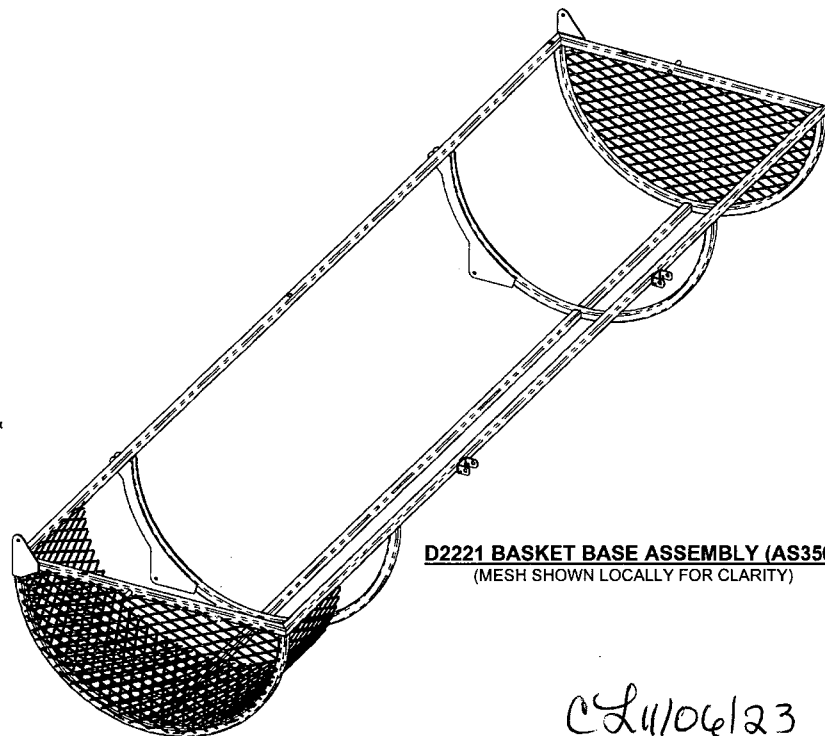
371834 → ②

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Shop Packet Print

Page 4





**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

CL4106123

WID: 71135

**NOTES:**

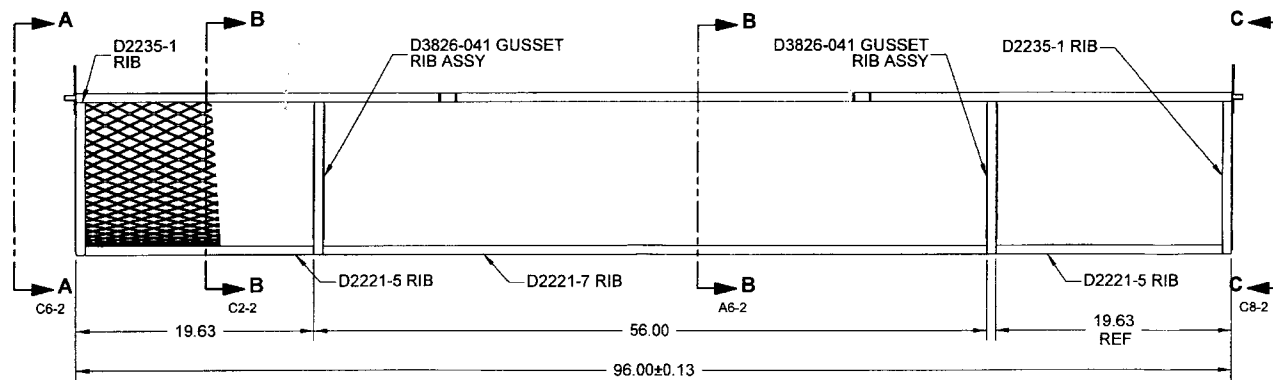
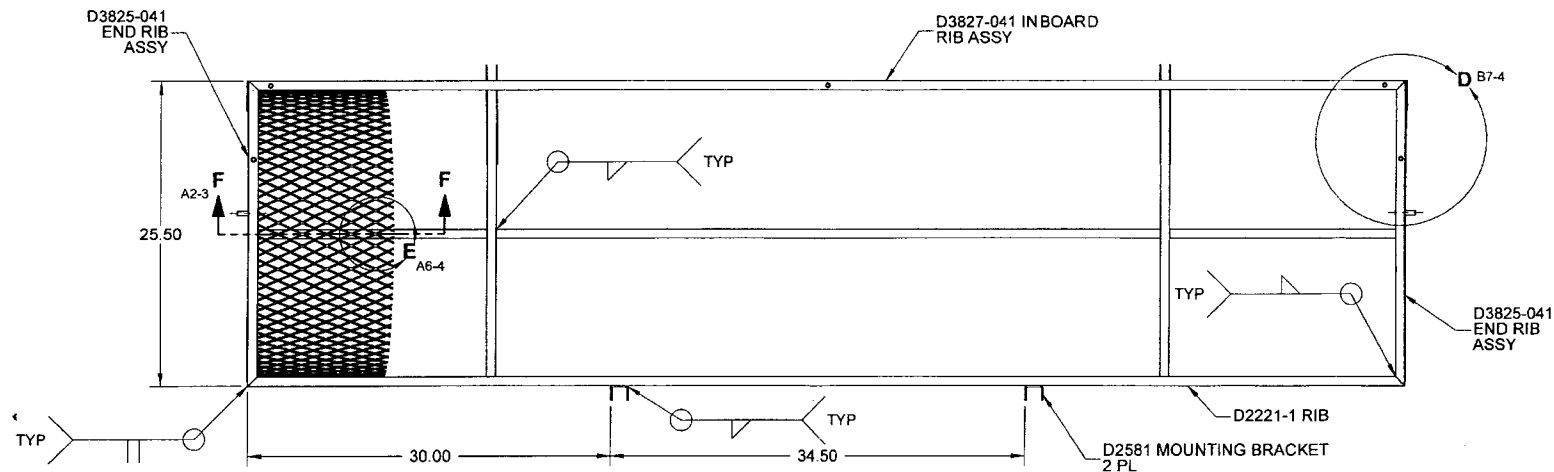
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)



RELEASED  
08/11/18

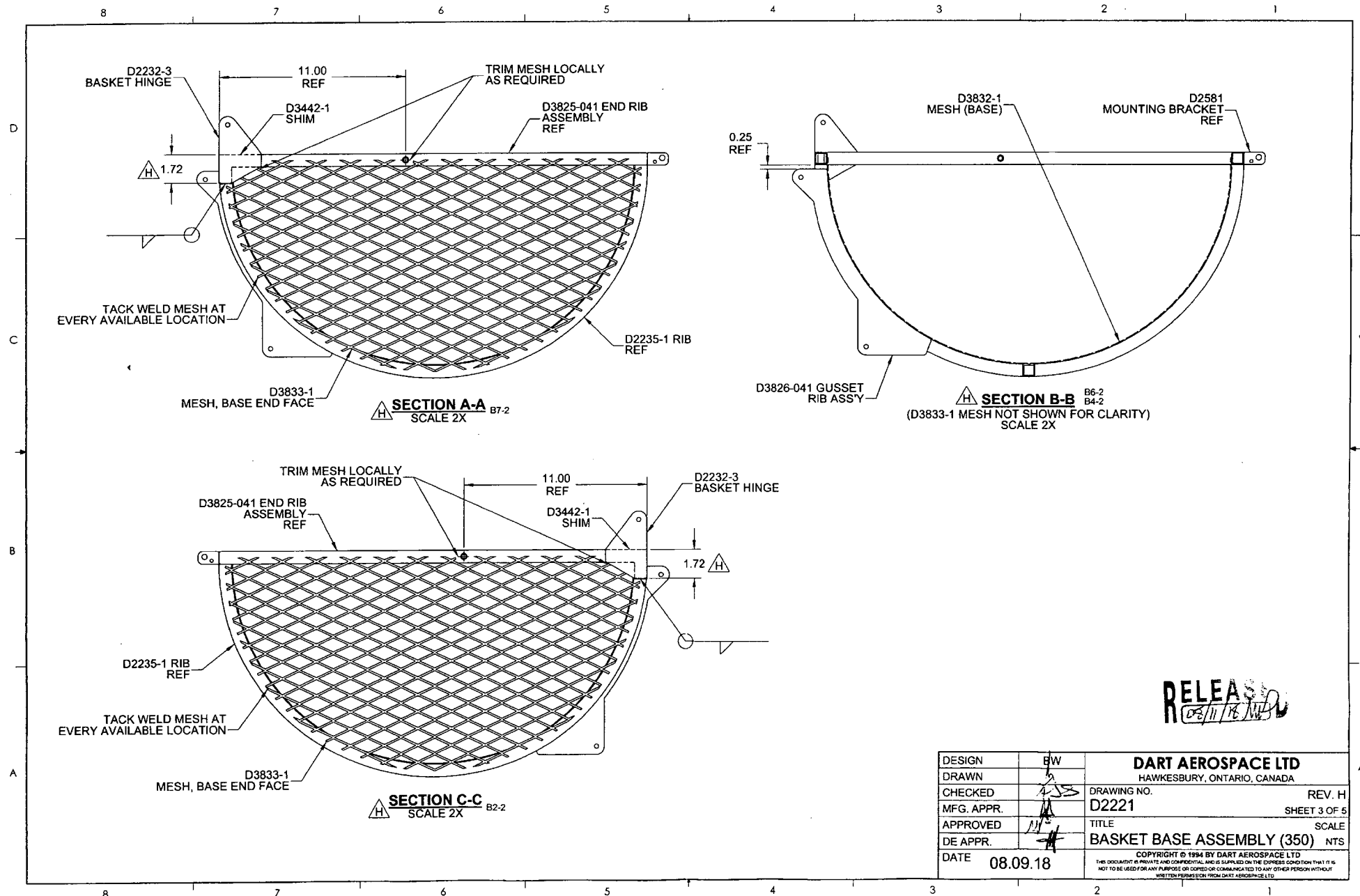
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS $\pm 0.01$ AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18 NED

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	433	DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.		TITLE	SCALE
APPROVED	11	<b>BASKET BASE ASSEMBLY (350)</b>	
DE APPR.		NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

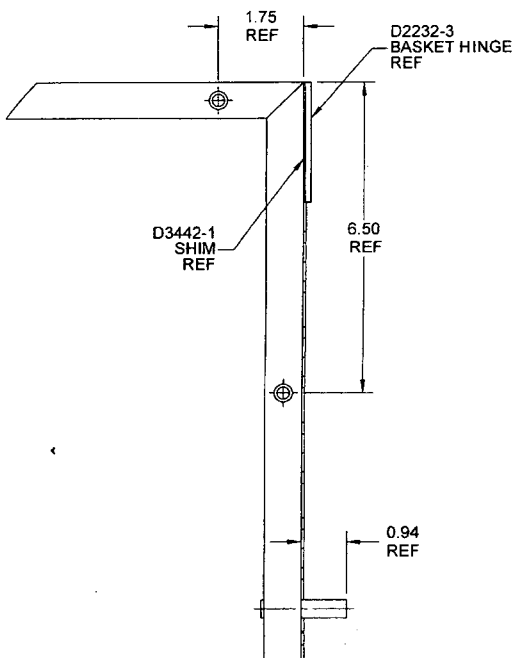
8 7 6 5 4 3 2 1

D

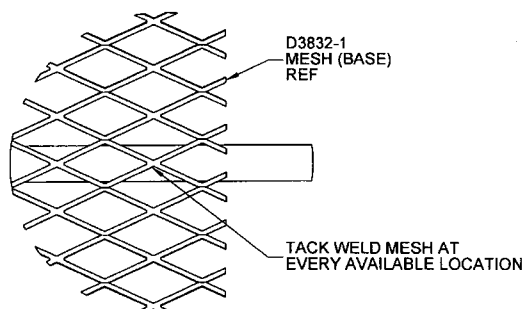
C

B

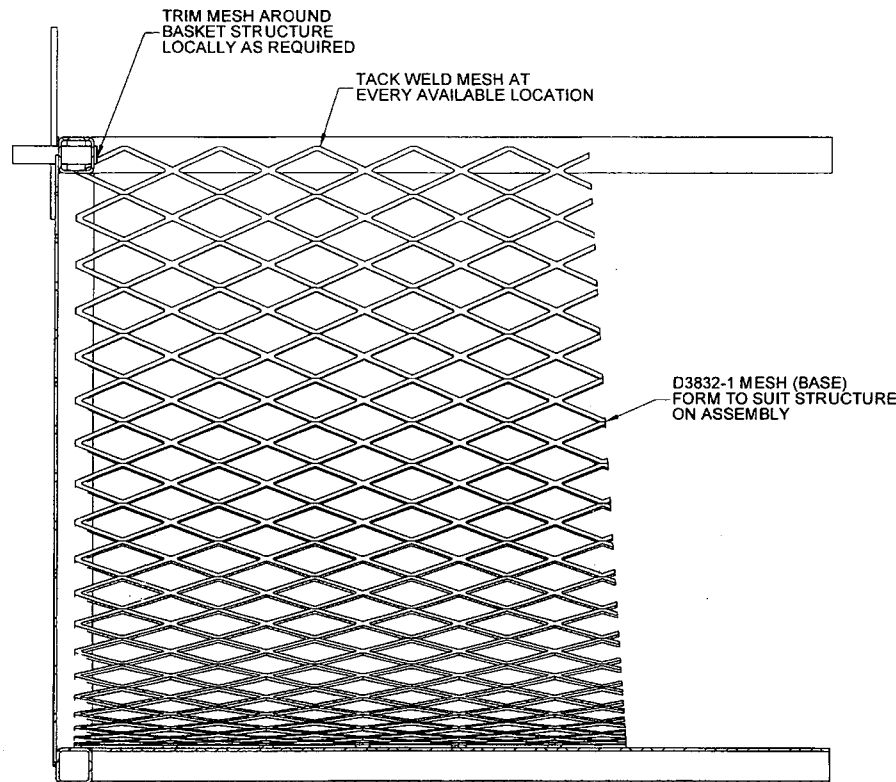
A



**DETAIL D**  
SCALE 4X D2-2



**DETAIL E**  
SCALE 4X C6-2

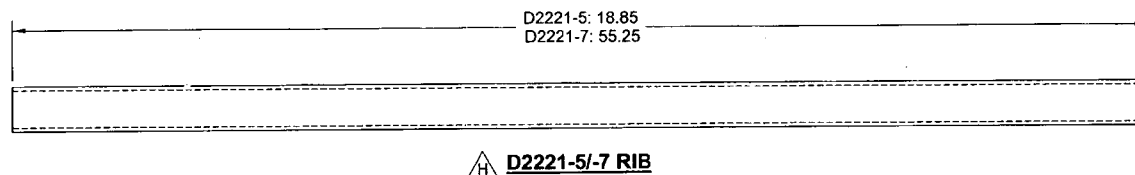
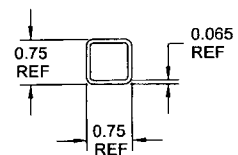
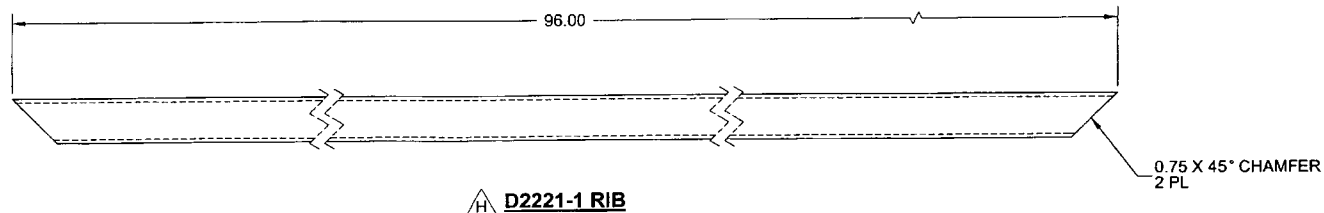
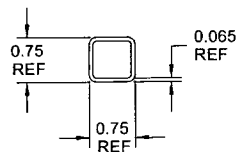


**SECTION F-F**  
SCALE 4X D7-2

**RELEASED**  
08/11/16

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1



RELEASED  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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